



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4686-1

Job Sheet 179498



Part No: D4686-1

Job Qty: 100 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/13/18

Created By: Jesse White

Type: Stock

Description:

Note: D4686 REV.B IPP REV:A 13.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 13-06-15 NEW LENGHT JLM
VERIFIED BY:DD IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	7/13/18	7/13/18	0.00	0.00	Start Up Machining-3		JRD 14/07/24
100	Hardinge	100 pcs	7/13/18	7/13/18	0.01	2.93	Hardinge		JRD 15/07/24
120	QC	100 pcs	7/13/18	7/13/18	0.00	0.00	QC8		18/07/26
122	Outsource	100 pcs	7/13/18	7/13/18			MEI001-VC		QC 18-7-30
124	Packaging	100 pcs	7/13/18	7/13/18	0.00	0.00	Packaging2		AUG 09 2018
126	QC	100 pcs	7/13/18	7/13/18	0.00	0.00	QC6		38
130	HandFinish	100 pcs	7/13/18	7/13/18	0.00	2.50	HandFinish1		DR 9-89 18-08-14
140	QC	100 pcs	7/13/18	7/13/18	0.00	0.00	QC7-4		68
150	Packaging	100 pcs	7/13/18	7/13/18	0.00	0.00	Packaging3-2		21
160	QC21-SA	100 Ea	7/13/18	7/13/18	0.00	0.00	QC21		AUG 15 2018

Part Op 100 - Machine as per Folio FB164

Descriptions: 122 - HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED
PART ARE MADE FROM 6061-T6 MATERIAL → P0040640 → metzor.

124 - ENSURE C OF C IS ATTACH

150 - ***STOCK IN SKIDTUBE CELL**

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.750W.058	6061-T6 Round Tube .750 X.058W	44 ft (.44 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.750W.058	44	39	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.750Inches $\pm$ 0.010	0.760 0.740		Reference, Diameter
2	Spacer	0.058Inches $\pm$ 0.010	0.068 0.048		Reference
3	Spacer	5.200Inches $\pm$ 0.063	5.263 5.138		

Plex 6/19/18 3:39 PM dart.white.jesse



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S095512



Part: D4686-1

Job No: 179498

Serial No/Batch: S095512

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/24/18



Dart Aerospace Ltd.
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Canada

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PURCHASE ORDER **PO040640**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040640
PO Date: 7/30/18
Due Date: 8/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179498	D4686-1	Spacer : Various STC's HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	-	8/8/18	100 pcs	0 pcs	100 pcs	\$4.30/pcs	\$430.00

100 X AUG 09 2018

Grand Total: \$430.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Plex 7/30/18 9:08 AM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
329399	1	130050

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
40640		AL-6061	2018/7/30	PICK UP

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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100 D4686-1
(100) D4686-1
JOB 179498

6,

DAS
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9-89

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
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QUANTITÉ EXPÉDIÉE / Quantity Shipped : 100

POIDS EXPÉDIÉ / Weight Shipped : 6,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 100

POIDS EXPÉDIÉ / Weight Shipped : 6,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/08/06

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329399	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40640	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCT	36 - 44 %IACS	20 (60 kHz)	40 - 42 %IACS	
HARDNESS	60 HREW MIN	20	68 - 72.5 HREW	
MESURE EN HR15TW = 67-69 HR15TW				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
100	6	D4686-1 (100) D4686-1 JOB 179498 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN
AGE HARDEN AMBIANT 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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06 AOÛT 2010

Isabel Otero
METCOR

DAS
38
9-89

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329399	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40640	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

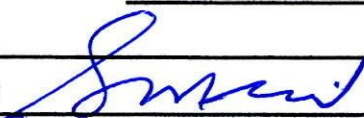
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	20	40 - 42 %IACS
HARDNESS	60 HREW MIN	20	68 - 72,5 HREW
MESURE EN HR15TW = 67-69 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
100	6	D4686-1 (100) D4686-1 JOB 179498 1 BOITE DE CARTON

10/8/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-08-06

APPROUVÉ

METCOR INC.

560 BOUL. ARTHUR SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél : 450-473-1884

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Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329399	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
40640	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXECUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS	20	40 - 42 %IACS
HARDNESS	60 HREW MIN	20	68 - 72,5 HREW
MESURE EN HR 15TW = 67-69 HR 15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
100	5	D4686-1 (100) D4686-1 JOB 179498 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-08-06